Work Orde August-28-13 12	er ID 106258 2:43:51 PM		*106	258*					٠		Page 1	
Revision ID:	D3574-5 Cabin Floor Protector		Accept	*N900	040	100) * S	Setup S	tart Stop		S1* S2*	
Start Date: Required Date:	8/28/13 Start Qty: 1.0 8/28/13 Req'd Qty: 1.0	•		Cust Item I Customer:	D:							i
Reference:		•										
Approvals:	Process Plan: ML5	Date: 13-08-	3○ Tooling:	Da	ıte:		I		Start	*NI	R1*	. (1) . (1)
,	QC:	Date:	SPC (Y/N):	Da	ite:			2	Stop	*NI	R2*	
Sequence ID/ Work Center II	Operation D Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		leject lumber	Insp. Stamp	
Draw Nbr	Revision Nbr											
D3 ¹ 574	Rev B											
*100 *100* Waterjet FLOW CNC Waterje	FLOW WATER JE Memo 1-Cut a		0.00 0.00 v: 18 Prog Rev: 3					0			<u>Ae</u> 13.12	. م
ver ver en		if necessary	_									
110	QC2- Inspect parts	off machine FAI/FAIB	0.00									
110 QC Quality Control	Мето		0.00								13.12) . 6
120	QC8- Inspect parts	- second check	0.00					13.	19.3) (7 r .	- 1 - 1 - 1 - 1 - 1
120	Momo		0.00					13-	13.5	37	<u>D</u>	

Quality Control

						•			DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UP		0.4.61	D. 1	
						-			QA Closed:	Date:	
Work Orde	ŕ:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is		Skid-tube Machining moforming	Crosstube Small Fab Finishing	ł	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier		Ì									
Training											
Unapproved					<u>.</u>						
						AULT CATI	GORY				
Landir	ng Gear			_	General				7		7
,	Bending			<u> </u>	Bend	Grain			Ovalized		Pressure/Forced
1	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardw			Over/Under		Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	⊢ .	tion Incomplete		Part Incorre	 	Weld
	Crushed/	'Crimped			Burrs		tions Incomplete/	'Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
),	Cuffs			L	Contamination	⊢	enance		Part Moved		
]	Heat Tre			_	Countersink	Mislab	eled		Positioned V	_	7
	Inspection	n Strip in	Tube		Cut Too Short	Misrea			Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

						·							
Work Orde				*106	325					Page 2			
Item ID: Revision ID: Item Name:	D3574-5 Cabin Floor	Protector		Accept	*N	1900	040	100)* 5	Setup	Start Stop	ı V.	S1* S2*
Start Date: Required Date: Reference:	8/28/13 8/28/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*			Cust Item I Customer:	D:						
Approvals:	Process Pl QC:	an:	Date:Date:		Date:]	Run	Start Stop	INKI	
Sequence ID/ Work Center II 130 *120* Small Fab Small Fab	D	Operation Description Small Fab Memo Deburr if ne	cessary.	Set Up/ Run Hours 0.00	V/A	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
140 *140* QC		QC5- Inspect part comp	eteness to step on W/O	0.00						13	-61-	31 l	D

150

Quality Control

Identify as per dwg & Stock Location: PPF
//05345

0.00

150 Packaging

Memo

0.00

Packaging

						•			DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-	CONFO	RMANCE / UP	PDATE			
					_				QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	tion of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Er	g Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											•
Setup	_					1					
Other					•						•
Process	<u> </u>						1				
Supplier						1.					
Training										:	
Unapproved										<u> </u>	
					F	AULT CA	EGORY				

ndin	g Gear	 General			_	_
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
ſ	Wave/Twist in Tube	Folio	Γ	Outside Dimensions		

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord			*106258*									Page 3
Item ID: Revision ID: Item Name:	D3574-5 Cabin Floor	Protector		Accept	*N900	040	100)*	Setup S	start Stop		S1*
Start Date: Required Date Reference:	8/28/13 : 8/28/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		nte:				Start Stop		R1* R2*
Sequence ID/ Work Center I	D	Operation Description QC21- Final Inspection	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp

0.00

Memo

Quality Control

MLJ 14-01-07 MLJ 14-01-07

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	ATE			-
									<u>-</u>		QA Closed:	Dat	e:
Work Ord	er:			_		DISPOSITION	7			AGAINST DE	PARTMENT,	•	
Part I	No.					Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No.					Work Order Update	_]		Large Fab	Composite		Supplier	
Root		*****			Descri	ption of work order update		Initial	Actio	on	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Cł	nief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data			ļ										
Equip/Tooling													
Operator	Ш												
Material	Ш							:					
Setup		·					:						
Other	Ш			[[
Process													
Supplier			1									1	
Training												1	
Unapproved						10.							
						F	AUI	LT CATE	GORY				
Landi		1				General	_	-			•		<u>.</u>
		Bending				Bend		Grain		ļ	Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to C)/S	BOM/Route	$oxed{L}$	Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	\perp	- ·	on incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs	L	Instruct	ions Incomplete/Ur	nclear	Part Lost/Mi	issing	Wrong Stock Pulled
	L	Cuffs			_	Contamination	<u> </u>	Mainte			Part Moved		
		Heat Trea				Countersink	L	Mislabe	led		Positioned V	Vrong	
		Inspectio	•	Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other
	L	Ripples in	n Bend			Drill Holes		Offset					
		Torque W	Vaves in E	Extrusion	ı	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

August-28-13 12:43:55 PM

Work Order ID: 106258

106258

Parent Item:

D3574-5

D3574-5

Parent Item Name: Cabin Floor Protector

Start Date: 8/28/13

Required Date: 8/28/13

Start Oty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A New Issue 07.07.23

EC

verified by:JLM

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location

Route Seq ID Location

Unit of Measure Hand

sf

Qty on

Qty per Kit Total

**

Qty Issued Qty

Date Status Issued

MLEXS.125-F60029-04

Purchased

No

2,471.452

Loc Code

25.35294

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

Location

Last

Loc Qty MAT018 2471.452 286.792 124866

m126425_ 2184.66

126425 -> 25.36

												DQA:	Dat	e:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFOR	MANCE / UP	DATE					
												QA Closed:	Dat	e:	
Work Ord	er.					DISPOSITION				AGAINST D	ΕI	PARTMENT	PROCESS		
Part I	No.					Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		ì	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	tion	1	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	1	QC Inspector
Doc/Data															
Equip/Tooling															
Operator											ı				
Material															
Setup	П														
Other															
Process							1								
Supplier	Г] [;			
Training															, .
Unapproved			İ												
						F	AUI	LT CATE	GORY						
Landi	ing (Gear				General		_				_	_		
		Bending				Bend		Grain				Ovalized			Pressure/Forced
	Г	Centre N	ot Conce	ntric to	o/s	BOM/Route	Г	Hardwa	ire			Over/Under	tolerance		Temperature/Cure
	Г	Cracks				Broken/Damaged		Inspect	ion Incomplete	Г		Part Incorrec	t [Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		٦	Part Moved			-
		Heat Trea	at			Countersink	Г	Mislabe	eled			Positioned W	/rong		

Misread

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	106258
Description: Cabin Floor Protector	Part Number:	D3574-5
Inspection Dwg: D3574 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3,00	_		V	JKm -05
7.37	+/-0.030	7,37			7	OKM-UL
11.00	+/-0.030	11.00			T	0.41.5
15.25	+/-0.030	15.25			T	
25.87	+/-0.030	25.87	_		Т	
39.75	+/-0.030	39.75	-		T	
44.75	+/-0.030	44.75	_		т	
49.11	+/-0.030	49.11	_		T	11111
51.11	+/-0.030	51.11			T	
1.75	+/-0.030	1.75	-		V	
58.38	+/-0.030	58.38	_		7	
63.50	+/-0.030	63.50	_		T	
65.25	+/-0.030	65.25	_		T	
11.87	+/-0.030	11.87			T	
14.75	+/-0.030	14.75			<u> </u>	
26.00	+/-0.030	26.00			T	
40.87	+/-0.030	40.87			T	
45.00	+/-0.030	45.00	-		T	. :
48.00	+/-0.030	48,00	-		T	
55.13	+/-0.030	55.13			T	
58.38	+/-0.030	58.25	_		Τ	
61.25	+/-0.030	61.25	_		T	
61.88	+/-0.030	61.88	_		T	
64.63	+/-0.030	64.63	_		T	
7.63	+/-0.030	7.63			T	
11.00	+/-0.030	// .00	_			
22.50	+/-0.030	22.50			T	
35.13	+/-0.030	35.13			<u> </u>	
36.50	+/-0.030	36.50	_		<u> </u>	· · · · · · · · · · · · · · · · · · ·
40.00	+/-0.030	40.00	_		T	
41.88	+/-0.030	41.88			T	
43.63	+/-0.030	43.63			T	
0.75	. / 0.000					
6.75	+/-0.030	V.75	_		T	

DART AEROSPACE LTD	Work Order:	106758
Description: Cabin Floor Protector	Part Number:	D3574-5
Inspection Dwg: D3574 Rev: B		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.50	+/-0.030	9,50	_		T	
10.38	+/-0.030	10,38			T	
14.50	+/-0.030	14.50	/		T	
16.75	+/-0.030	16.75			Ť	
19.00	+/-0.030	19.00			T	
24.13	+/-0.030	04.43	-		T	
33.88	+/-0.030	33, 88	-		T	
39.50	+/-0.030	39.50	_		T	
40.25	+/-0.030	40.25	1		T	•
43.50	+/-0.030	43.50	1		1	
43.83	+/-0.030	43.83	_		T	
46.60	+/-0.030	46.60			7	
0.125	+/-0.010	1125			V	

Measured by:	Audited by: β	Prototype Approval:	N/A
Date: 13.12.28	Date: 13.12.31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ//DD	
В	08.07.31	1.13 dimension removed	KJ/DD	
С	09.05.15	Dimensions updated per Dwg Rev B	KJ \$	<u> </u>

30.75 63 13 63 63 22.50 11.50 11.00 32.33.36 REF 7.37 10.75 10.75 11.00 11.00 15.25 14.75 25.50 \oplus 25.87 25.75 R1.50 - 26.00 2 PL 32.87 R200.0 -- 38.81 39.75 44.75 44.75 45.00 B 1.75 49.11 51.11 48.25 53.51 Ø3.00 TYP 58.38 61.25 63.50 64.13 64.63 65.25 0.125 66.50 REF R0.25 TYP 46.60 43.83 43.50 40.25 39.50 33.88 30.50 26.50 24.13 75 50 50 50 50 50 **ある4000℃**

MUS PELEASED

00

0

D

С

0 0

ADD CUT-OUT TO -1/-5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5; -2 NOW SHOWN ON SHEET 2 09.03.25 NEW ISSUE A СВ 07.06.08 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED REV. B D3574 MFG. APPR. SHEET 1 OF 6 TITLE APPROVED SCALE **CABIN FLOOR PROTECTOR** DE APPR. DATE

D3574-1 CABIN FLOOR PROTECTOR

1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART

7) WEIGHT: 14.30 lbs 8) CHECK PER TEMPLATE DT8961

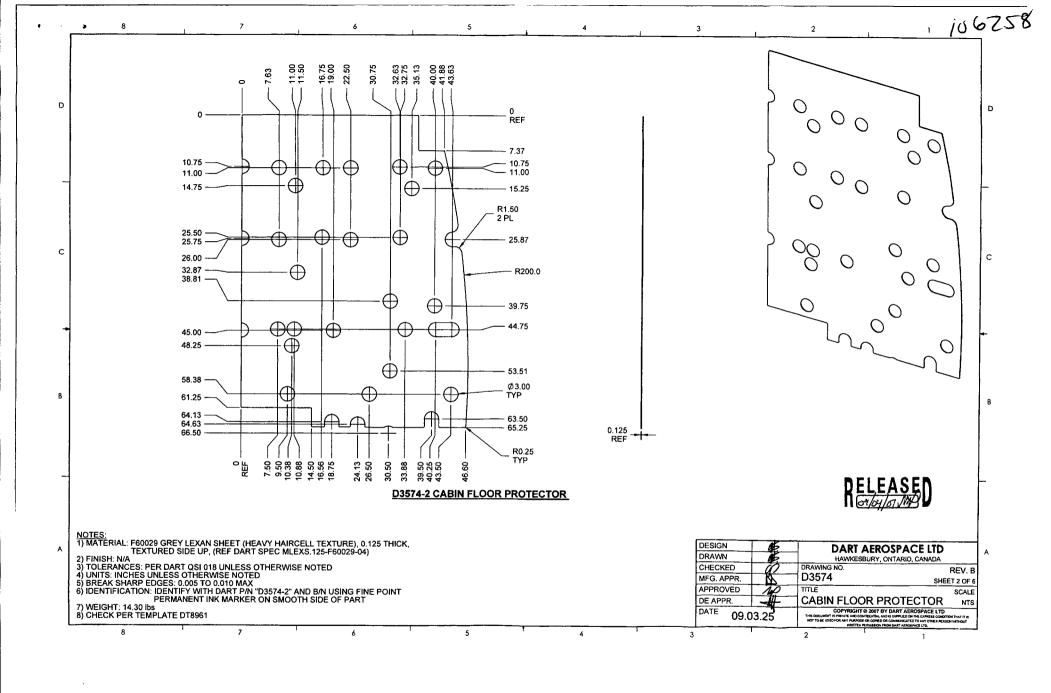
COPYRIGHT © 2007 BY DART AEROSPACE LTD

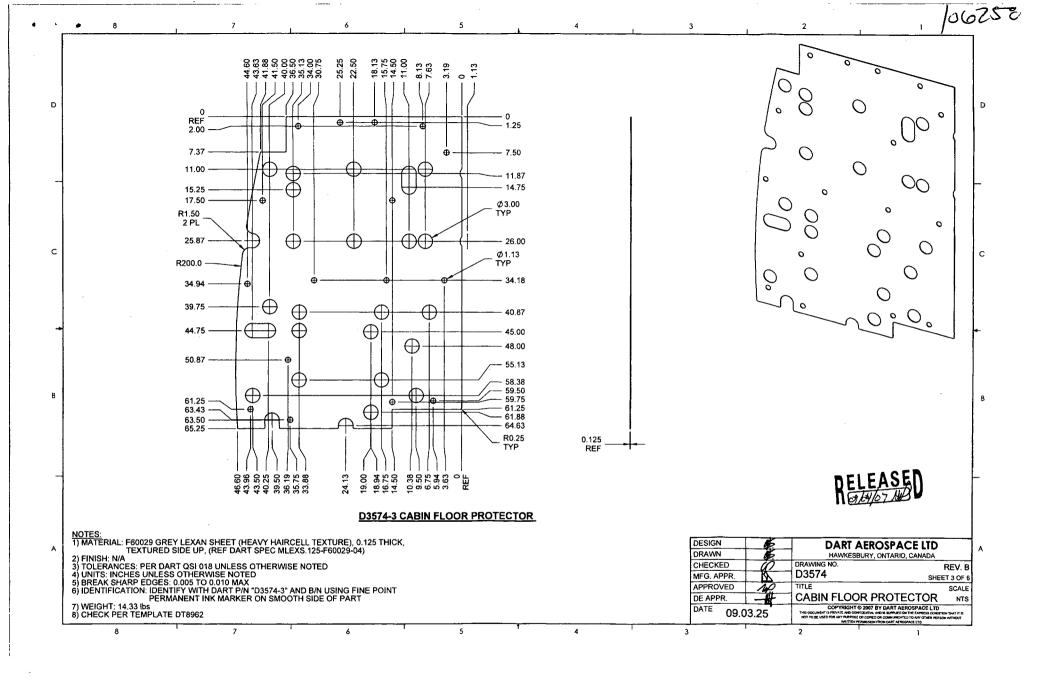
IT IS PRIVATE MO COMPELITUL, AND IS SUPPLED ON THE EXPRESS CONCITENT THAT IT IS

ITS DRIVE MY PURPOSES ON COMPENION TO NOW OTHER PURSON WITHOUT

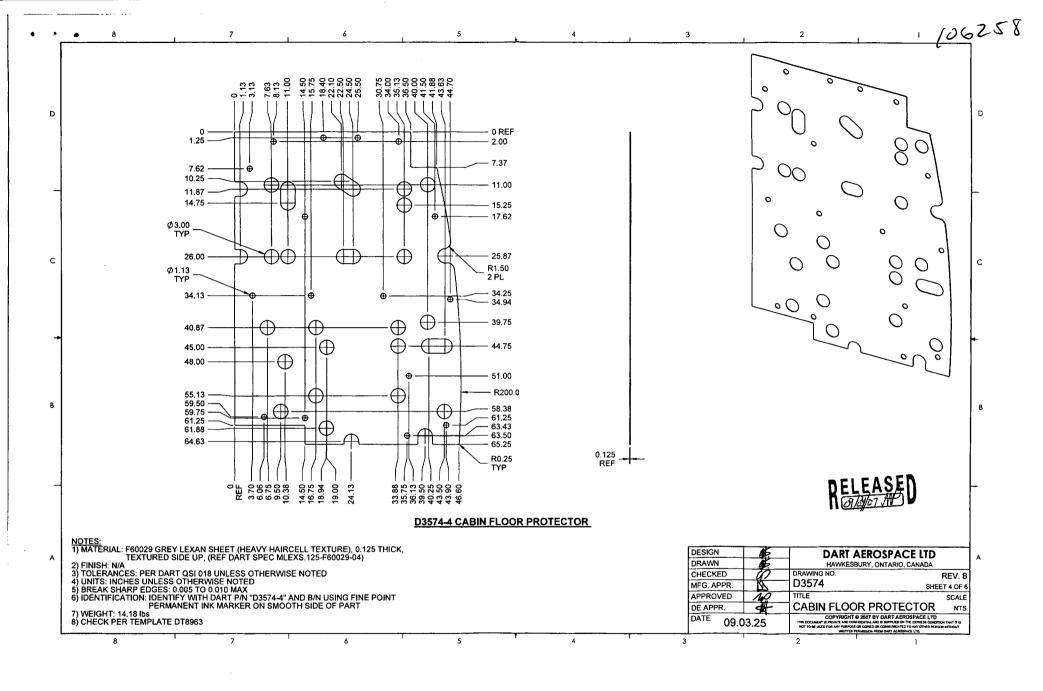
09.03.25

3

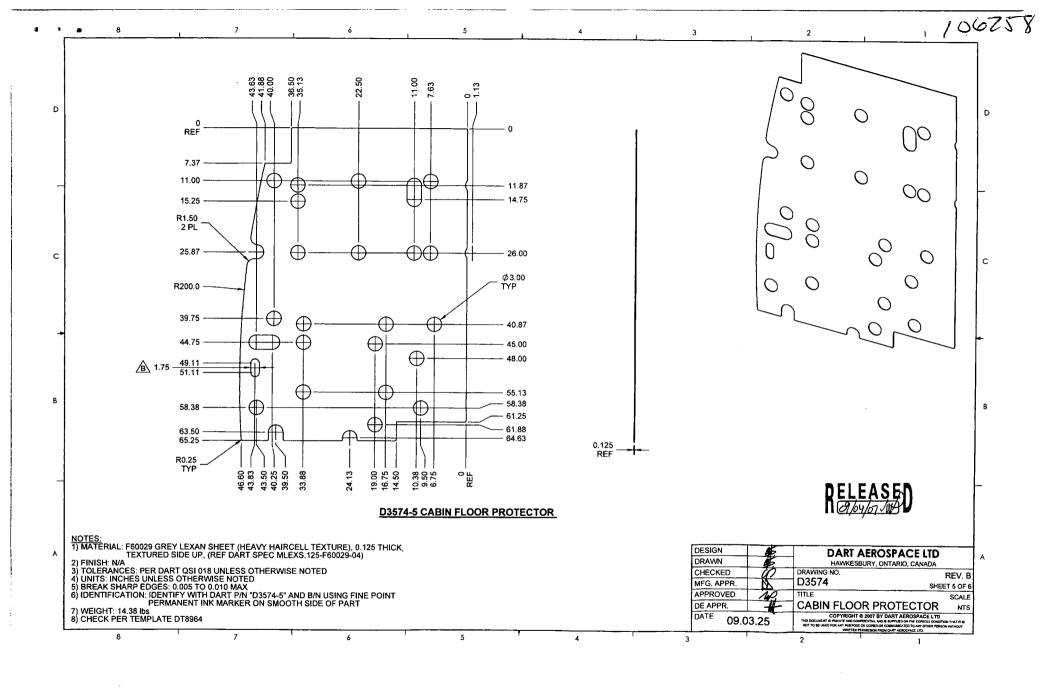




	्रे विकास क्षेत्र क्षेत्र का क्षेत्र का कुरार क्ष्मुं स्थान क्षेत्र का किए का विकास का किए का विकास का किए का क विकास का किए			1.77.38
Section of the sectio				
		·		
\$ \$7 \$ \$ \$ \$				
ē.				
&				
• • •				
4.4	نْ مُرَّدُّ اللهُ الله			



	- The Control of National State (1) A St		·	1 1783
ŕ				
•				
s'				
				<u> </u>
•				
				į. S
•				ĺ
<i>y</i>				
•				3
** ** - *				
N 26 30				
,				
· • :				9
·				
)- e				
	·			
terre. Books				
3				
1				
ž.				
항				
ř				
} }:				
ET .				
,				
ř E 1				
• • •				
	- Commission of Control of Contro			,

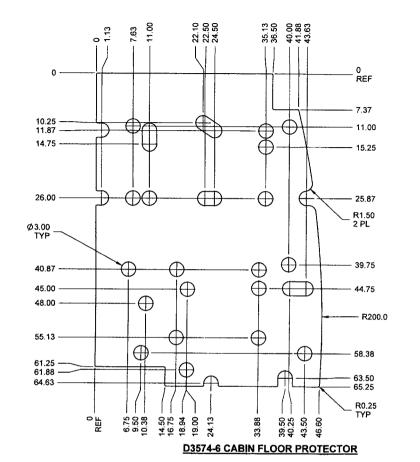


	- Prof. Confection Confection Selection (Application Confection		1 . (7)
i.			
:			
8			
ř.			
# as #		•	
	distribution of the state of th	•	

106759

D

С



NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK,
TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)

25 🍎

2) FINISH: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART

7) WEIGHT: 14.27 lbs
8) CHECK PER TEMPLATE DT8965

DESIGN	16	DART AEROSPACE LTD	
DRAWN	16	HAWKESBURY, ONTARIO, CANADA	
CHECKED	a	DRAWING NO. REV. B.	
MFG. APPR.	100	D3574 SHEET 6 OF 6	
APPROVED	140	TITLE SCALE	
DE APPR.	4	CABIN FLOOR PROTECTOR NTS	
DATE 09.03.25		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIMATE AND CONFERENTIAL AND IS SUPPLIED ON THE EDITERS CONDITION THAT IT IS HIGT TO BE URED FOR ANY PARROES ON COMPANYED TO COMPANYED TO ANY OTHER PRISON WITHOUT	

0.125

REF